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*Reprint
8/25*

RBEM632V4000102
Job Sheet 182796



5932

Part No: RBEM632V4000102

Job Qty: 1 pcs

Part Name: Rotor Brake Rigging Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/6/18

Created By: Logan David

Type: SOLD

Description:

Note: REV 1 SHEET 1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/6/18	0.00	0.00	Start Up Small Fab-4		<i>MLL</i>
110	Small Fab	1 pcs		9/6/18	0.00	0.00	Small Fab-6		<i>MLL</i> <i>DAS</i>
120	QC	1 pcs		9/6/18	0.00	0.00	QC5		<i>38</i>
130	Packaging	1 pcs		9/6/18	0.00	0.00	Packaging3-1		<i>MLL</i> <i>9-89</i>
140	QC	1 pcs		9/6/18	0.00	0.00	QC21		<i>21</i> <i>OCT 17 2018</i>

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver as per Dart QSI 044 2-Transfer drill Dart placard RB41011

Descriptions: into Pelican case APP-11230-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBEM632V4000102-11 to RBEM632V4000102-17 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	<i>5075949</i>
APP-1120-E	Case	1 Ea (1 ea)	90-Start up Operation	<i>5112940</i>
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	<i>5021040</i>
RBEM632V4000102-1	Clamp Assembly	<i>2</i> Ea (1 ea)	90-Start up Operation	<i>5118940</i>
RBEM632V4000102-11	Placard, Plastic	1 Ea (1 ea)	90-Start up Operation	<i>5107893</i>
RBEM632V4000102-15	Bottom Foam use in case APP-1120-E	1 pcs (1 ea)	90-Start up Operation	<i>5112934</i>
RBEM632V4000102-17	Top Foam use in case APP-1120-E	1 pcs (1 ea)	90-Start up Operation	<i>5112937</i>
RBEM632V4000102-9	Shim	2 Ea (2 ea)	90-Start up Operation	<i>5115196</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	995	0
	APP-1120-E	1	8	0
	RB41011	1	773	0
	RBEM632V4000102-1	1	0	0
	RBEM632V4000102-11	1	4	0
	RBEM632V4000102-15	1	1	0
	RBEM632V4000102-17	1	1	0
	RBEM632V4000102-9	2	0	0



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CANADA

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Container No: S118768

Part: FBEM632V4000102

Job No: 182796

Serial No/Batch: S118768

Revision:

Inspector:

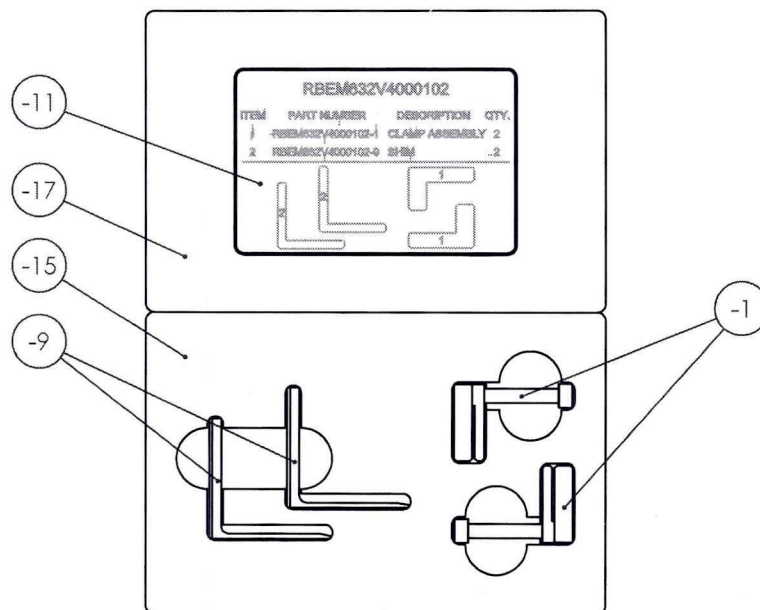
Exp Date:

Instructions:

Date: 10/16/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	6/13/2016	DPD	JAG



NOTES:
REF. AIRBUS T/N: M632V4000102.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	CLAMP ASSEMBLY			2
	1		-3		CLAMP BASE	6061		3
	1		-5		CLAMP TOP	6061		4
	1		-7		SOCKET HEAD CAP SCREW	STEEL	M6 X 1mm X 45mm (MCMMASTER-CARR #91290A204) MODIFIED	5
			-9	2	SHIM	1018/1020 CR		6
			-11	1	PLACARD	PLASTIC		7
	1	B/O	-13		EXTERNAL RETAINING RING	STEEL	Ø5/32 SHAFT (MCMMASTER-CARR #97633A115)	2
		B/O	-15	1	BOTTOM FOAM	Y20 BLACK	2.55 X 4.93 X 7.43 (I.R. SPECIALTY)	8
		B/O	-17	1	TOP FOAM	Y20 BLACK	.72 X 4.93 X 7.43 (I.R. SPECIALTY)	9
		B/O	-19	1	CASE	PLASTIC	PELICAN #APP-1120-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
	ASSY -1							

TITLE
ROTOR BRAKE RIGGING SHIM

DWG NO. RBEM632V4000102 **REV** 1

MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:3	DATE 4/14/2016
SHEET 1 OF 9	